

Work Order ID 120322

Wednesday, June 04, 2014 3:02:00 PM

120322

Page 1

Item ID: D412-704-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cable Ass'Y
 Start Date: 6/04/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-06-06 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9611	A								
IIN D412-704	C								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

1 FF 14-10-06

① DAS 38 9-89 14-10-06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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120322

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>SJ2217</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

1X SP 14-10-7

14/10/7

14-10-07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 120322

120322

Parent Item: D412-704-045

D412-704-045

Parent Item Name: Cable Ass'Y

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B05.01.28 Added Figures 1-2KJ/RF

IPP Rev:C 08-10-08 as per revB DD verified by:EC

IPP REV:D

12.05.10 per DSI 9611 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A		Purchased	No			100	Each	473.0000	1	1			

AN3-10A

Bolt

**

FF 14-10-06

Location

Loc Qty

Loc Code

ST351

173

m127817

36

m128403

137

ST511

300

m128813

150

m128936

150

AN3-5A

Purchased

No

100

Each

314.0000

1

1

AN3-5A

Bolt

**

FF 14-10-06

Location

Loc Qty

Loc Code

GA

129507

45

117423

45

ST511

185

m126559

92

m129246

93

ST512

84

124561

84

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 120322

120322

Parent Item: D412-704-045

D412-704-045

Parent Item Name: Cable Ass'Y

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 1.00

Required Qty: 1.00

D3217-3

Manufactured No

100

Each

6.0000

1

1

D3217-3

Cable 80.5"

FF 14-10-06

Location

Loc Qty

Loc Code

ST222

5

116986

5

ST223

1

113710

1

D3257-1

Manufactured No

100

Each

6.0000

1

1

D3257-1

Fitting

FF 14-10-06

Location

Loc Qty

Loc Code

ST035

6

117072

6

D3258-1

Manufactured No

100

Each

9.0000

1

1

D3258-1

Angle Bracket

FF 14-10-06

Location

Loc Qty

Loc Code

ST035

9

101595

9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

Work Order ID: 120322

120322

Parent Item: D412-704-045

D412-704-045

Parent Item Name: Cable Ass'Y

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

6,310.000

2

2

MS21042L3

Nut

FF 14-10-06

Location

Loc Qty

Loc Code

ST314

109

108816

9

M127410

13

M127831

39

M128401

48

ST506

955

123900

955

ST509

5246

M127831

2

M128754

5244

2

NAS1149D0332J

Purchased

No

100

Each

3,405.000

2

2

NAS1149D0332J

Washer

FF 14-10-06

Location

Loc Qty

Loc Code

ST294

375

m128606

375

ST510a

3030

m128612

3030

2

NAS1149D0363J

Purchased

No

100

Each

3,732.000

2

2

NAS1149D0363J

Washer

FF 14-10-06

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

3709

109061

9

m126319

6

m128429

3694

2

Wednesday, June 04, 2014 3:02:00 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Wednesday, June 04, 2014 3:02:00 PM

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Work Order ID: 120322

120322

Parent Item: D412-704-045

D412-704-045

Parent Item Name: Cable Ass'Y

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 1.00

Required Qty: 1.00

NAS509-3

Purchased

No

100

Each

14.0000

3

3

NAS509-3

FF 14-10-06

Nut

Location

Loc Qty

Loc Code

ST276

129472

14

M128110

14

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-704 REV. C OR EARLIER
AND ICA-D412-704 REV. 4 OR EARLIER
REF CANADIAN STC SH93-34
REF FAA STC SR00957NY
REF EASA STC EASA.IM.R.00696

PURPOSE

The purpose of this Dart Service Instruction is to correct part number error in Installations Instruction IIN-D412-704 Rev. C or earlier and Instructions for Continued Airworthiness ICA-D412-704 Rev. 4 or earlier. The AN3-13A bolt should be replaced with an AN3-10A bolt in Figure 5 - Detail L in IIN-D412-704 and Figure 25-4 Detail L in ICA-D412-704. See sheet 2.

PART LIST CORRECTION

Revise Part Lists in IIN-D412-704 & ICA-D412-704 as follows:

NOW

Qty -043	Qty -045	Part Number	Description
X		D205-704-043	CABLE ASSEMBLY (205)
	X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
1	1	AN3-10A	BOLT

WAS

Qty -043	Qty -045	Part Number	Description
X		D205-704-043	CABLE ASSEMBLY (205)
	X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
1	1	AN3-13A	BOLT

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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

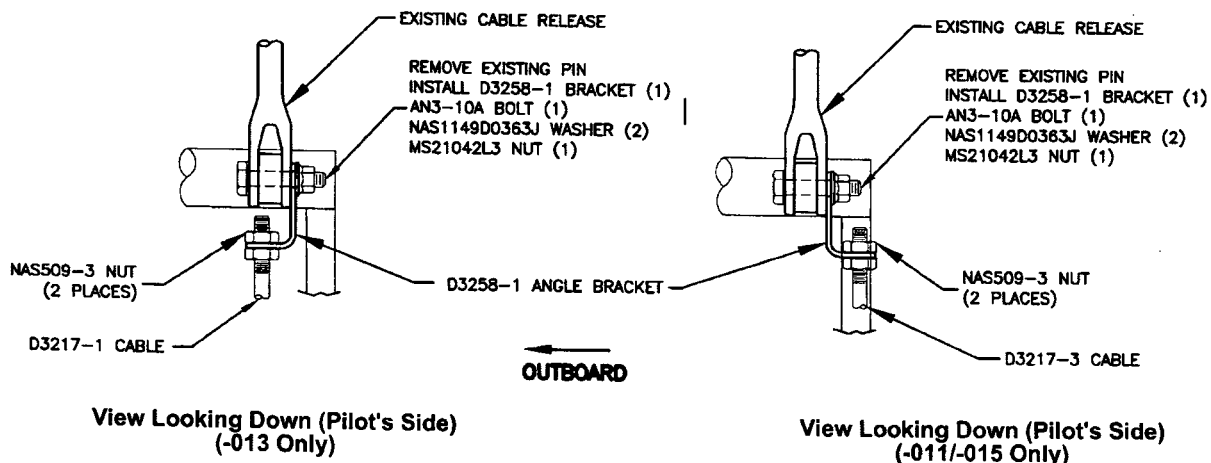
DATE: 12.05.07
CERT. NO.: SH93-34
ISSUE NO.: 2

A	NEW ISSUE (REF PAR)	RF	12.05.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	N/A	DSI 9611	SHEET 1 OF 2
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FIGURES CORRECTION

Revise Detail L Figure 5 of IIN-D412-704 and Detail L Figure 25-4 of ICA-D412-704 as follows:

NOW



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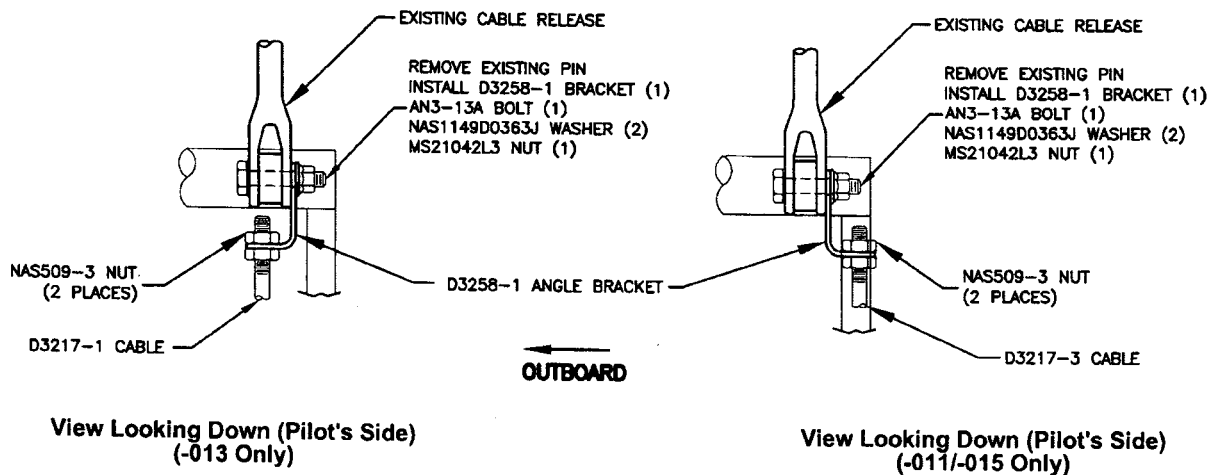


Figure 5 - Detail L or Figure 25-4 - Detail L

CANADA
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AIRCRAFT CERTIFICATION
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DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

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